

58LIT

Date: Wednesday, 12/20/2006 11:59:11 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 29994  
Estimate Number : 10288  
P.O. Number : N/A  
This Issue : 12/20/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL / MED FAB  
Previous Run : 29488  
Drawing Name : WEARPLATE  
Part Number : D25771  
Drawing Number : D2577 REV E  
Project Number : N/A  
Drawing Revision : E  
Material : N/A  
Due Date : 1/10/2007 Qty: 40 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est: E 02.09.24 Re-format; Incorporated D2577 101/-11 KJ/  
RF  
est F 06.09.11 now waterjet EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8474 sf(s)/Unit Total: 33.8940 sf(s)  
1010/1025/A21/6aA SHEET

1103788

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2577 (D2577-101 detail)  
Dwg Rev: E  
Prog Rev: E

07 03 15

40

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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40

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/03/19 40

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179  
2-Form joggle as per Dwg D2577 using DT8157  
3-Identify as D2577-1  
4-Deburr if nesasary

07-03-23  
07 103 26  
07 103 22

40  
40





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29994

Part Number: D25771

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/26

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty

Description

Batch

A/R 7560 Hardcoat Rod

ML3372

FC 07 03 29 (11)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/29 (11)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

ML

07-03-29

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/03/29

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

FC

07/03/29

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion



07-03-29





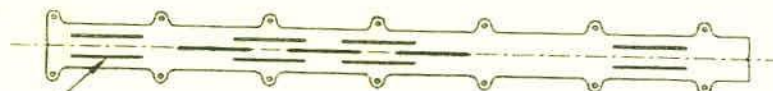
**DART**



RELEASED  
00 09 22 11

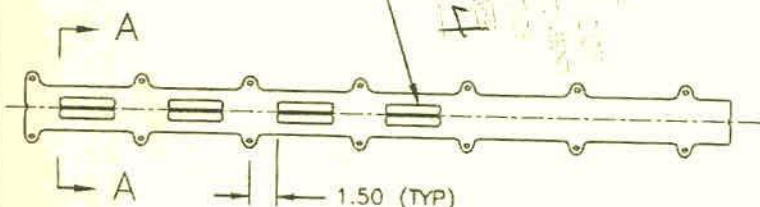
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DATE	REV. E
00.09.22	00.09.22	SHEET 1 OF 5
		SCALE
		1:10
A	96.09.16	WEARSHOE
B	96.12.04	NEW ISSUE
C	97.05.30	ADD HARDCOAT WELDS
D	98.08.17	CHANGE HOLES TO OBOUNDS
E	00.09.22	CORRECTED DIMENSIONS ON -1 & -3
		ADD D2577-101/-11/-13
		INCORPORATE DE09176

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

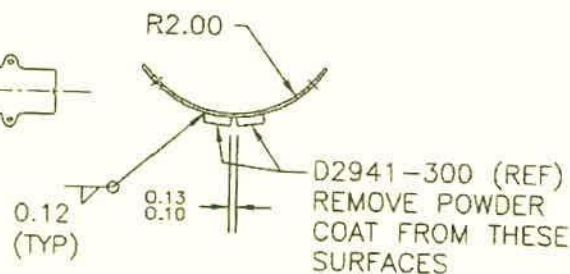


D2577-1 & D2577-3 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)



SECTION A-A  
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





ART AEROSPACE LTD		Work Order: 29994
Description: <u>Wearplate</u>		Part Number: <u>D2577-1</u>
Inspection Dwg: <u>D2577</u> Rev: <u>E</u>		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Inspected as per template D2577-1/3		✓			
B						
C						
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <u>mm mm</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	N/A
Date: <u>07/03/15</u>	Date: <u>07/03/19</u>	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

